Dart Aerospace Ltd. Thursday, 04/09/2008 1:22:59 PM Date User Julie Lecocq **Process Sheet** Customer : MOUNTING LUG : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 41819 : 10255 **Estimate Number** : D22301 P.O. Number **Part Number** This Issue : 04/09/2008 S.O. No. : **Drawing Number** . D2230 REV F : NC : N/A Prsht Rev. **Project Number** First Issue : // : MACHINED PARTS Type **Drawing Revision** : 40934 **Previous Run** Material **Due Date** : 06/10/2008 Qty: 200 Um: Written By Checked & Approved By Added inspection level 8, and removed P/O for Comment : Est D 00.11.01 powder coat **Additional Product** Job Number: Machine Or Operation: Seq. #: Description: 1.0 D2423 Lug Extrusion Comment: Qty.: 14.3430 f(s) 0.0717 f(s)/Unit Total: Lug Extrusion D2423 Extrusion Batch: <u>B33310</u> 2.0 BAND SAW Le Cuta meter Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: 3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 muchine as per dug D2230 REU. F 1-Machine per folio D2230-1 (Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

4.0

INSPECT PARTS AS THEY COME OFF MACHINE

ec'd tunspool faithanail dumage. cufcattached.

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 5

SECOND CHECK

countre

200

Each

Comment: SECOND CHECK

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Dart Aerospace Ltd

W/O:	•		WO	RK ORDER CHAN	GES	•				
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DATE	STEP	Description of NC			ection B	Sign &	Verific		Approval	Approval
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NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:22:59 PM User: 🔌 Julie Lecocq **Process Sheet Drawing Name: MOUNTING LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 41819 Part Number: D22301 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 8.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: QC3 9.0 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Form: rprocess

Page 2

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W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
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DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Section C		Chief Eng	QC Inspector
					:				
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41819
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230 Rev: F		Page 1 of 1

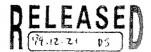
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	f c	omments
4.450	+/-0.010						
0.306	+/-0.010					72	
0.345	+/-0.010						
0.400	+/-0.010						
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Rev Date	Change New Issue					Revised b	y Appi



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	#	**	D2230 SHEET 1 (OF 2
DATE			TITLE	CALE
99.1	2.13		MOUNTING LUG	1:1
С		94.03.30	RE-DESIGN	
D		95.01.04	RE-DESIGN	
Ε		95.01.04	RE-DESIGN	
-		00 10 17	OFDECION - 04 000 W/C 04 400	



MACHINE

TO SIZE

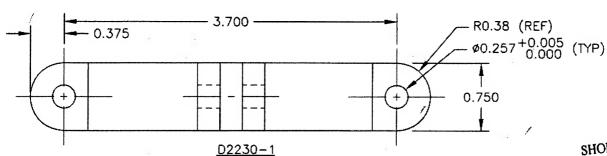
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SYMMETRIC ABOUT Q			
MACHINE TO SIZE			
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	R0.125		
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F R1.200	02/10	(REF)	
0.345			
0.345 —			
		0.400	
0.250		RO.:	38

ENGRAVE PART NUMBER

TO DEPTH OF 0.010±0.005

IN THIS LOCATION, WITH TOOL

TIP RADIUS OF 0.015±0.005



MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

0.735

(REF)

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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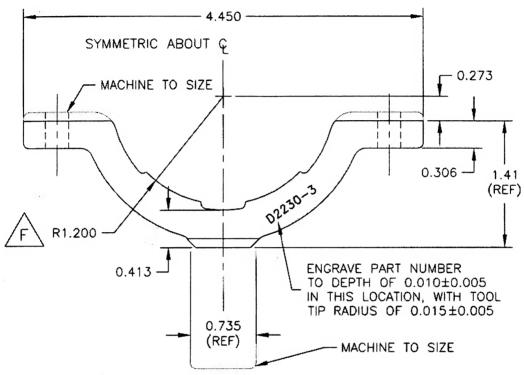
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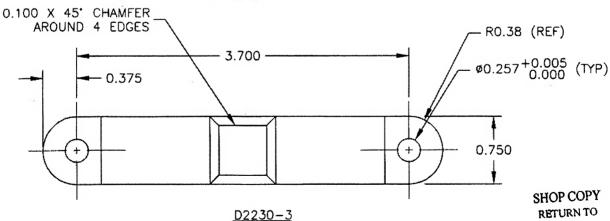




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RELEASED PAGE DE





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER



CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

QUANTITY PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-1

K6A 1K7

Lug 42232

7126

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, October 7, 2008

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